

Date: Tuesday, 03/03/2009 4:18:16 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PEDAL ASSEMBLY
Job Number	: 46296		
Estimate Number	: 11005		
P.O. Number	:	Part Number	: D412704041
This Issue	: 03/03/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D412-704-041 REV A
First Issue	: / /	Project Number	: N/A
Previous Run	: 43431	Drawing Revision	: A 609.03.05
	Type : SMALL /MED FAB	Material	:
Written By	:	Due Date	: 16/03/2009
Checked & Approved By	: JUD 09.03.04	Qty:	2 Um: Each
Comment	: Est Rev:B 05.01.28 Removed hardware on Step 2; Added Figures 1-3 KJ/RF Est Rev:C 06.03.08 Re-format EC Est Rev:D 07-03-20 Added Dwg D412-704-041 07-03-20 JLM Est Rev:E 07.05.02 Reformat EC Est Rev:F 08-10-08 as per revB DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D3204041	Release Pedal Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	D3204-041	Pedal Assembly	343613

2.0	D32051	Pedal Bracket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	D3205-1	Bracket	43301 x 1 35854 x 1

3.0	D32053	Back Plate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	D3205-3	GHW Bracket	35209

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Part Number: D412704041

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

D32061

Pedal Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	D3206-1	Pedal arm	36 535 B43619 (12)

88 09/03/12 (12)

5.0

D3209041

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	D3209-.041	Bracket	37 170 x 1 38 190 x 1

B43621 (12) 09/03/12 (12)

6.0

AN310A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	AN3-10A	Bolt	M17566

88 09/03/12 (12)

7.0

AN3154R

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	AN315-4R	Nut	M17566

88 09/03/12 (12)

8.0

AN410A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	AN4-10A	Bolt	167178

88 09/03/12 (12)

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Part Number: D412704041

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

AN412A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
2	AN4-12A	Bolt	M110704

SS 09/03/12 (X)

10.0

AN413A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	AN4-13A	Bolt	M110865

SS 09/03/12 (X)

11.0

AN960JD10

Washer



Comment: Qty.: 5.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty	Part number	Description	batch
5	AN960JD10	Washer	M110523

SS 09/03/12 (X)

12.0

AN960JD416

Washer



Comment: Qty.: 11.0000 Each(s)/Unit Total : 22.0000 Each(s)

Pick:

Qty	Part number	Description	batch
11	AN960JD416	Washer	M110523

SS 09/03/12 (X)

13.0

AN960JD416L

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part number	Description	batch
3	AN960JD416L	Washer	M110153

SS 09/03/12 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Part Number: D412704041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

MS21042L3

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : ~~3~~ 6.0000 Each(s)

Pick:

Qty

Part number

Description

batch

MS21042L3

Nut

M110399

SS 09/03/12 (X2)

15.0

MS21042L4

Nut



Comment: Qty.: 5.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty

Part number

Description

batch

5

MS21042L4

Nut

M109282

SS 09/03/12 (X2)

16.0

MS24694S102

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty

Part number

Description

batch

1

MS24694S102

Screw

M14604

SS 09/03/12 (X2)

17.0

MS951910

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty

Part number

Description

batch

1

MS9519-10

Bolt

M100290

SS 09/03/12 (X2)

18.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble pedal as per Dwg D412-704-041

Tighten & Torque Bolts as per Dwg D412-704-041

SS 09/03/12 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Part Number: D412704041

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 09/03/20

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0

AN960JD10L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty

Part number

Description

batch

4

AN960JD10L

Washer

M108632

22.0

AN36A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty

Part number

Description

batch

2

AN3-6A

Bolt

M109752

23.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Nut

Batch:

M110399

24.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

SB 09/03/23 (T3)

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

58197

PC9/3/23 (T3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

QC21

FINAL INSPECTION/W/O RELEASE



09/03/24

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mk
09-03-24

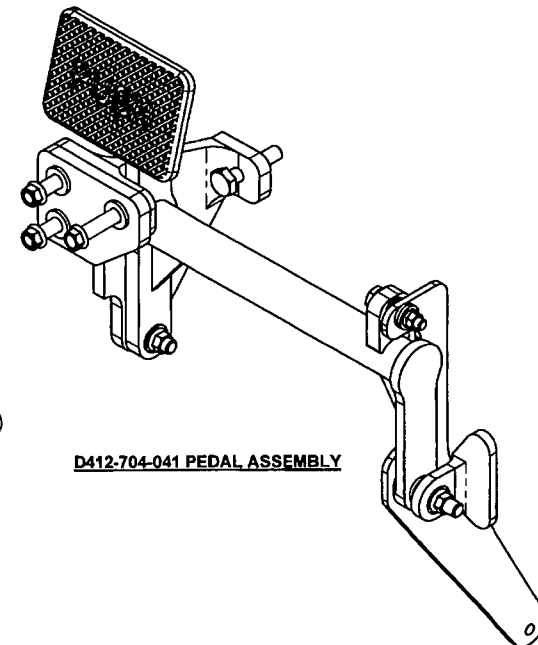
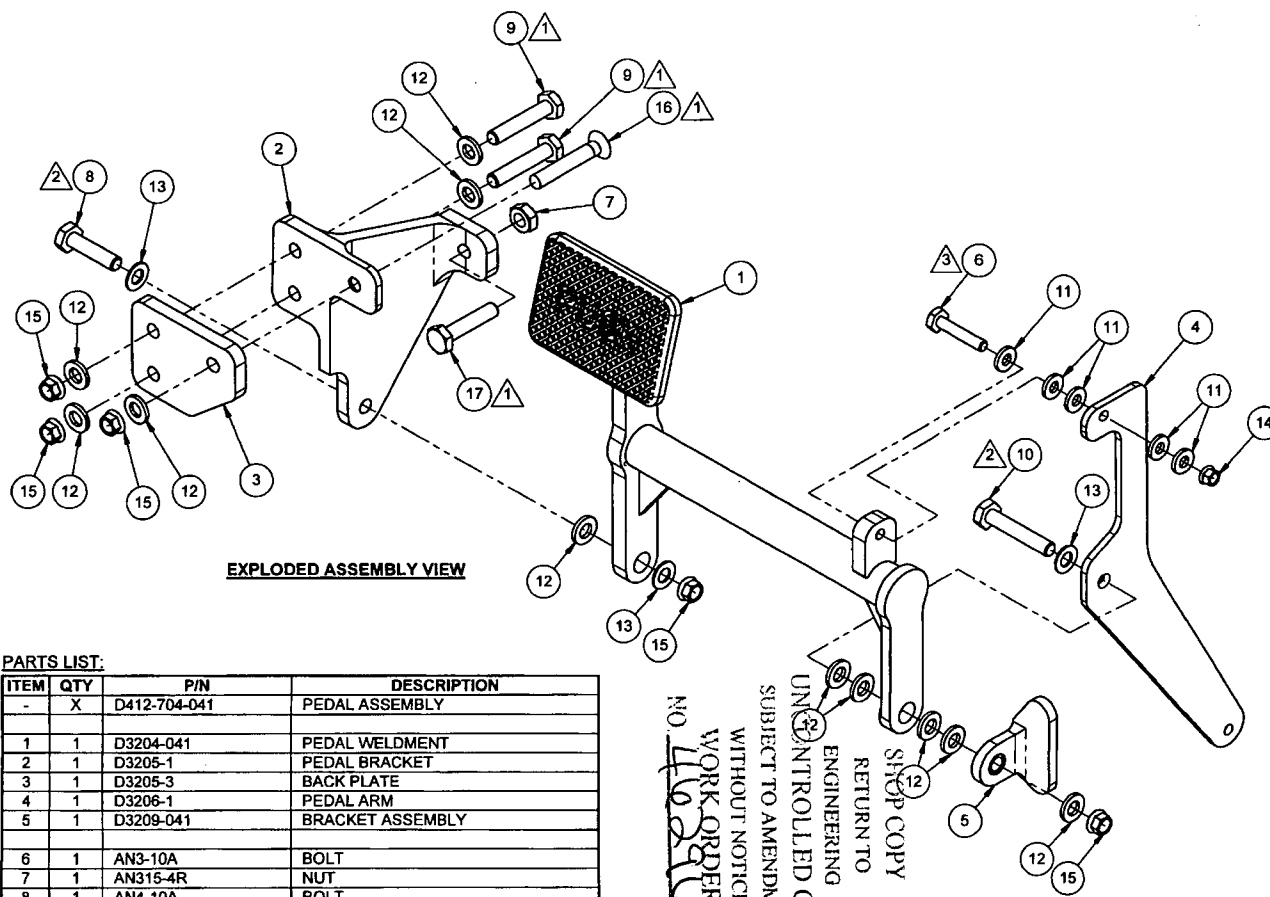
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D412-704-041 PEDAL ASSEMBLY

PARTS LIST:

ITEM	QTY	P/N	DESCRIPTION
-	X	D412-704-041	PEDAL ASSEMBLY
1	1	D3204-041	PEDAL WELDMENT
2	1	D3205-1	PEDAL BRACKET
3	1	D3205-3	BACK PLATE
4	1	D3206-1	PEDAL ARM
5	1	D3209-041	BRACKET ASSEMBLY
6	1	AN3-10A	BOLT
7	1	AN315-4R	NUT
8	1	AN4-10A	BOLT
9	2	AN4-12A	BOLT
10	1	AN4-13A	BOLT
11	5	AN960JD10	WASHER
12	11	AN960JD416	WASHER
13	3	AN960JD416L	WASHER
14	1	MS21042L3	NUT (OR MS21042-3)
15	5	MS21042L4	NUT (OR MS21042-4)
16	1	MS24694-S102	SCREW
17	1	MS9519-10	BOLT
N/A*	2	AN3-6A	BOLT
N/A*	4	AN960JD10L	WASHER
N/A*	2	MS21042L3	NUT (OR MS21042-3)

* SHIPPED LOOSE WITH -041 KIT (NOT PRE-ASSEMBLED AT DART)

NO WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

NOTES:

1. INSTALL IDENTIFIED FASTENERS LOOSE (HAND TIGHTEN ONLY).
2. TIGHTEN IDENTIFIED FASTENERS UNTIL SNUG. ENSURE THAT PARTS CAN STILL ROTATE.
3. TORQUE IDENTIFIED FASTENERS TO 15-25 in-lbs (1.7-2.8 N-m).

RELEASED

07.01.23

A	REV	DATE	NEW ISSUE	DESCRIPTION
DESIGN	CB	DRAWN BY	CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	CE	APPROVED	DATE	DRAWING NO. D412-704-041 TITLE PEDAL ASSEMBLY
07.01.23				REV. A SHEET 1 OF 1 SCALE 1:2

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